

20-8759



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2594-3**Job Sheet 210982****Part No:** D2594-3**Job Qty:** 49 pcs**Part Name:** O-Ring**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/30/20**Job Tracking No:****Created By:** Kimberley Guerin**Due Date:** 7/3/20**Description:****Note:** DWG REV C IPP B 04.06.08 Reformat; Added Powder Coat KJ/JLM IPP C 06.12.11 ecn 836 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	49 pcs		7/3/20	0.00	0.00	Purchasing - 1		JUN 30 2020
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	49 pcs		7/3/20	0.00	0.00	Packaging 2 - 1 - B4B		JUN 30 2020
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		

**Container No:** S285583**Part:** D2594-3**Job No:** 210982**Serial No/Batch:** S285583**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/30/20

Plex 6/30/20 10:47 AM Dart.Guerin.Kimberley

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
120 QC 6	49 pcs	7/3/20	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
					QC 6 - 82	
130 Packaging 3-1 - Stock - B4B	49 pcs	7/3/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
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					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140 QC 21 - SA	49 pcs	7/3/20	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	

Part Op 100 - (Purchasing) Issue P/O: _____ Purchase as per Dwg D2594 Possible P/N: Parker 2-011
 Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached
 120 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MS28775-011	O-Ring D2594-3	49 pcs (1 ea)	100-Purchasing	S795582

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	MS28775-011	49	0	0

Part Specifications

Specifications could not be found.

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB046648



Supplier: AVI002-VU
Aviall
PO BOX 842267
Dallas, TX 75284-2267 USA
Phone: 905-676-1695
Fax: 905-676-9046

PO No: POHB046648
PO Date: 6/25/20
Due Date: 6/29/20
Purchase Order Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Fedex P1 Overnight
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		600.1012			Sealant PR1425B2 (#654 sem)	Firmed X10	-	6/29/20	10 pcs	0 pcs	10 pcs	\$66.94/pcs	\$669.40
2		AN3C4A		25/pk	Bolt	Firmed X200	-	6/29/20	200 Ea	0 Ea	200 Ea	\$0.30/Ea	\$60.00
3		AN4-11A		50/pk	Bolt	Firmed X50	-	6/29/20	50 Ea	0 Ea	50 Ea	\$0.13/Ea	\$6.50
4		AN4-51A		5/pk	Bolt	Firmed X100	-	6/29/20	100 Ea	0 Ea	100 Ea	\$1.40/Ea	\$140.00
5		AN4-6A		50/pk	Bolt	Firmed X100	-	6/29/20	100 Ea	0 Ea	100 Ea	\$0.10/Ea	\$10.00
6		NAS1149D0463J			Washer	Firmed X100	-	6/29/20	600 Ea	0 Ea	600 Ea	\$0.03/Ea	\$18.00
7		MS21042L08		50/pk	Nut	Firmed X200	-	6/29/20	200 Ea	0 Ea	200 Ea	\$0.18/Ea	\$36.00
8		MS27039-08-19		100/pk	Screw	Firmed X100	-	6/29/20	100 Ea	0 Ea	100 Ea	\$0.30/Ea	\$30.00
9		MS27039-1-12		100/pk	Screw	Firmed X100	-	6/29/20	100 Ea	0 Ea	100 Ea	\$0.10/Ea	\$10.00
10		NAS1149C0332R		200/pk	Washer (AN960C10L)	Firmed X1200	-	6/29/20	1,200 Ea	0 Ea	1,200	\$0.03/Ea	\$36.00
11		2600-6		5/pk	Camlock Stud	Firmed X30	-	6/29/20	30 Ea	0 Ea	30 Ea	\$1.72/Ea	\$51.60
12		AN3-45A			Bolt	Firmed X20	-	6/29/20	20 Ea	0 Ea	20 Ea	\$1.25/Ea	\$25.00
13		AN3C5A		25/pk	Bolt	Firmed X200	-	6/29/20	200 Ea	0 Ea	200 Ea	\$0.28/Ea	\$56.00
14		AN4-16A		50/pk	Bolt	Firmed X200	-	6/29/20	200 Ea	0 Ea	200 Ea	\$0.22/Ea	\$44.00



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PURCHASE ORDER **POHB046648**



Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
15		AN6-12A			Bolt	Firmed	-	6/29/20	140 Ea	0 Ea	140 Ea	\$0.37/Ea	\$51.80
16		MS21042L6		50/pk	Nut	Firmed	-	6/29/20	100 Ea	0 Ea	100 Ea	\$0.70/Ea	\$70.00
17		MS21042L3	DSI9760-011		Nut	Firmed	-	6/29/20	300 Ea	0 Ea	300 Ea	\$0.16/Ea	\$48.00
18		MS21044N8		10/pk	Nut, Self-Lock .500-20, UNJF-3B	Firmed	-	6/29/20	20 Ea	0 Ea	20 Ea	\$0.39/Ea	\$7.80
19	210791	MS28775-011			O-Ring D2594-3	Firmed	-	6/29/20	500 pcs	0 pcs	500 pcs	\$0.15/pcs	\$75.00
20		NAS1149D0363J			Washer receive ea	Firmed	-	6/29/20	200 Ea	0 Ea	200 Ea	\$0.03/Ea	\$6.00
21		NAS1149D0432J		200/pk	Washer	Firmed	-	6/29/20	200 Ea	0 Ea	200 Ea	\$0.03/Ea	\$6.00
22		NAS1149D0663J		100/pk	Washer	Firmed	-	6/29/20	200 Ea	0 Ea	200 Ea	\$0.03/Ea	\$6.00
23		NAS1149F0332P			Washer (AN960-10L)	Firmed	-	6/29/20	600 Ea	0 Ea	600 Ea	\$0.03/Ea	\$18.00

Grand Total: \$1,481.10

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A032 DOCUMENT SPECIAL REQUIREMENTS

A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS

A040 NOTIFICATION OF QUALITY ESCAPE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/25/20 12:04 PM Dart.Guerin.Kimberley



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PACKING LIST



DELIVERY NUMBER: 8008835778

ROUTE: US FedEx International Priority

PAGE: 1 OF 3
DATE: 26 JUN 20
TIME: 14:53:17
EMP: 00000000
ORD TYP: ZCOM 132

CUSTOMER PO: POHB046648
ORDER NUMBER: 1005963931
ORDER DATE: 25 JUN 20

10003951
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
CANADA

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2750 REGENT BLVD
DALLAS TX 75261
USA

LINE	PO LINE	MFG	ITEM DESCRIPTION	ORDER QUANTITY	SHIP QUANTITY	QUANTITY BACK ORDER	UOM
0010	0	28	AN4-51A BOLT: HEX HD,ST	100	100 ✓	0	EA
			BATCH 7365438040		100		
0020	0	28	AN4-6A BOLT: HEX HD,ST	100	100 ✓	0	EA
			BATCH 7365364232		100		
0030	0	28	MS21042L08 NUT: SELF-LKG,ST	200	200 ✓	0	EA
			BATCH 7365434514		200		
0040	0	28	MS27039-0819 SCREW: PAN HD,ST	100	100 ✓	0	EA
			BATCH 7365435123		100		
0050	0	28	MS27039-1-12 SCREW: PAN HD,ST	100	100 ✓	0	EA
			BATCH 7365434883		100		
0060	0	28	NAS1149C0332R WASHER: FLT,ST	1,200	1,200 ✓	0	EA

RECEIVED

JUN 29 2020

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This Certificate of Conformance affirms that the products, articles or parts referenced on this document are new or overhauled, are traceable to the approved source and, when required, were manufactured under an aviation Authority approval. All Original Manufacturers' Certifications are maintained and can be made available upon request. For overhauled or repaired products, the original FAA 8130-3/EASA Form 1 or equivalent aviation Authority tag is attached to the component. Products, articles or parts were not subjected to adverse operating conditions or excessive temperatures.

Signature

26 JUN 20
Date

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DALLAS CDC
2750 REGENT BLVD
DALLAS TX 75261
USA

LINE	PO LINE	MFG	ITEM DESCRIPTION	ORDER QUANTITY	SHIP QUANTITY	QUANTITY BACK ORDER	UOM			
			BATCH 7365310829		1,200					
0070	0	28	2600-6 STUD: 1/4 TURN,ST	30	30 ✓		0 EA			
			BATCH 7365369786		30					
0080	0	28	AN3-45A BOLT: HEX HD,ST	20	20 ✓		0 EA			
			BATCH 7365135379		20					
0090	0	28	AN3C5A BOLT: HEX HD,SS	200	200 ✓		0 EA			
			BATCH 7365390453		200					
0100	0	28	AN4-16A BOLT: HEX HD,ST	200	200 ✓		0 EA			
			BATCH 7365368916		200					
0110	0	15	MS28775-011 ORING: NITRILE,70	500	500		0 EA			
			BATCH 7365202060		49					
			BATCH 7365407784		451					

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P 2750 REGENT BLVD
DALLAS TX 75261
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LINE	PO LINE	MFG	ITEM DESCRIPTION	ORDER QUANTITY	SHIP QUANTITY	QUANTITY BACK ORDER	UOM			
10120	0	28	NAS1149D0663J ✓ WASHER: FLT,AL BATCH 7365249720	200	200 ✓	0	EA			

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Signature

26 JUN 20
Date

DISCOUNT TERMS APPLY ONLY TO SUB TOTAL. ALL
RETURNED MERCHANDISE SUBJECT TO HANDLING
FEE.

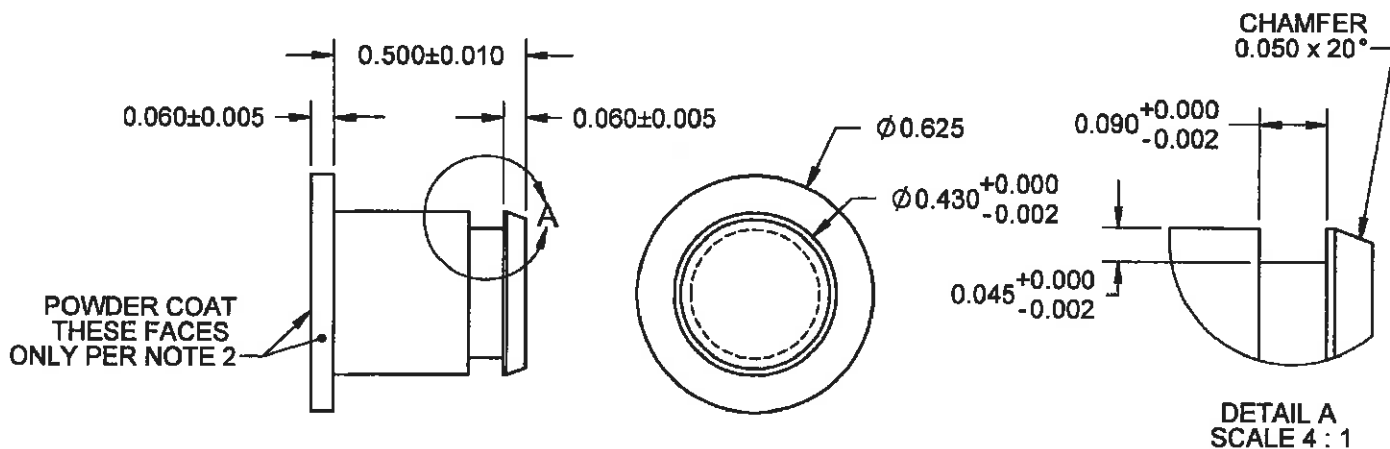
CUSTOMER COPY



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG		SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28 [Signature]

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

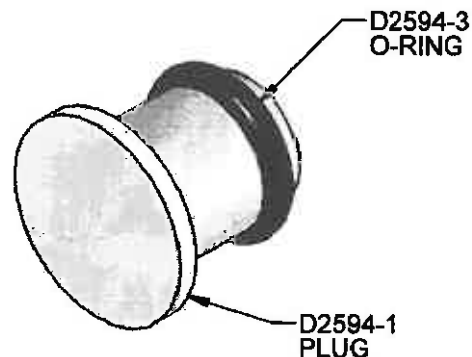
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 $\triangle C$

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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Oil-Resistant Mil. Spec. Buna-N O-Ring

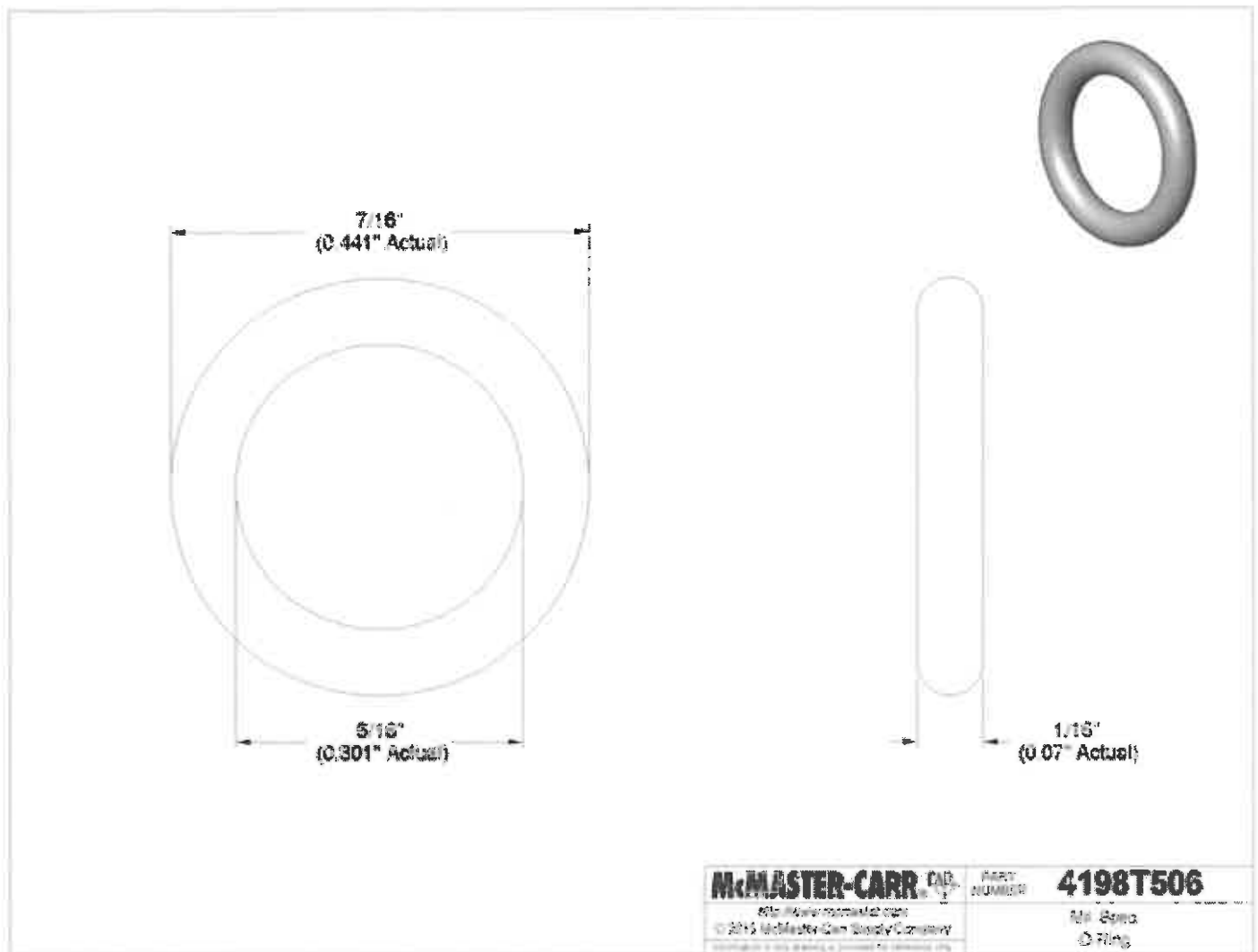
1/16 Fractional Width, Dash No. 011, -65° to 275°F

\$11.26 per pack of 50
4198T506



Material	Buna-N Rubber
Cross Section Shape	Round
Dash Number	011
Fractional	
Width	1/16
ID	5/16
OD	7/16
Actual	
Width	0.07"
ID	0.301"
OD	0.441"
Hardness	Durometer 70A (Medium)
For Use With	Ammonia Animal Oils Boric Acid Butyl Alcohol Calcium Hydroxide Citric Acid Ethylene Glycol Glycerin Isopropyl Alcohol Mineral Oils Motor Oil Potassium Hydroxide Sodium Bicarbonate Vegetable Oils
Specifications Met	ASTM D2000, MIL-P-25732, SAE AS568, SAE J200
Temperature Range	-65° to 275° F
Color	Black
RoHS	RoHS 3 (2015/863/EU) Compliant
REACH	REACH (EC 1907/2006) (01/16/2020, 205 SVHC) Compliant
Country of Origin	United States

Choose these O-rings for their adherence to strict military standards for material and construction. Made of Buna-N, they are resilient and offer resistance to tearing, motor oil, ammonia, ethylene glycol, isopropyl alcohol, and mineral oil. These O-rings have a round profile and are suitable for a wide range of static and dynamic sealing applications. All are sized to the SAE standard AS568.



The information in this 3-D model is provided for reference only.

Welcome to Boeing distribution, formerly Aviall

PARTS SERVICES DOCUMENTS & SUPPORT CONTACT US

Home Hardware & Standard Parts Seals & Gaskets ORING: NITRILE,70, HYD

ORING: NITRILE,70, HYD

Proponent
Part # MS28775-011=15

Log in to
or register for an

MIL-H-5606 compatible o-ring. Replaces
AN6227 -6. ID 0.301 Thickness .070

✓ In-stock and ready to ship



NSN 5330-00-582-2133	Cage Code 59789	Country of origin United States	ECCN / USML 9A991.d	Schedule B 4016930000
Dimensions (L x W x H) 3.5 x 3.25 x .07 IN	Total Shelf Life (days) 5475	Hazmat Code	Package Weight .01 LB	FAA Approval Code STD
ISBN	Condition	Color	Brand	Hazmat(Y/N) N
LTL(Y/N) N	8130-3 Eligible No	UN Code		

Item Replacement History

Part Number: MS28775-11 ORING: NITRILE,70, USE MS28775-011=15
Part Number: AN6227-6 PACKING,
Part Number: AN6227-3 ORING: RUBBER,BUTADIENE, USE MS28775-011=15

About Our Data Please help us and other customers. If there are corrections we should make to our information, please contact us.

OUR COMPANY	PROGRAMS	CUSTOMER SERVICE	INFORMATION	KEEP IN TOUCH
Careers	AOG Services Helicopter Solutions GE Aircraft Engines RestockMe	Order Status Support Center Contact Us Returns List Price	Shipping Policy eCatalogs Our Locations EU Reach Suppliers	Sign Up for emails 1-800-824-3331

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8259.

Route update only ☐

Job: <u>210982</u> Part No. <u>D2594-3</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier Quality ☒			
Date: <u>JUL 03 2020</u>		Sequence #: <u>QC-6</u>		QTY Affected: <u>49 pcs</u>		MRB (QSI042)	
Description Work Order Deviation				Disposition		<u>PD 20.07.03</u>	
Drawing calls for an ID of .3125", measuring .2655". OD calls .4375, measuring .3695" width of ring should be .0625", is .0675". Look like supplier send us MS29513-010				Return to supplier for replacement Customer issue credit, will be scrap at Dart		Completed By <u>PD 20.8.4</u> Lead hand / Supervisor	
						<u>PD 20.7.29</u> QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☒ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up			
				Other/Details: <u>wrong part send for supplier.</u>			